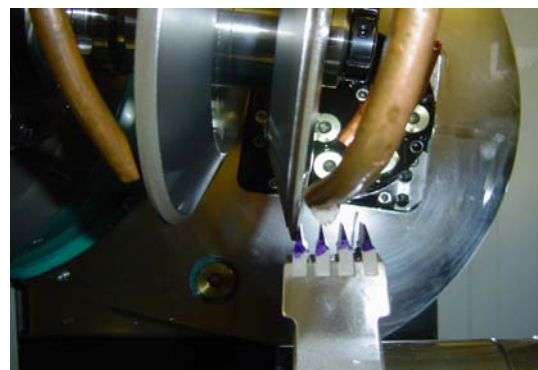


## Finger Joint Cutter

A16-280

To achieve a good surface finish on the sides, cupwheels are used for the finishing operation, as shown in the picture besides. In addition, the proposed grinding principle generates perfectly straight clearances.



### 1. Cycletime for Production

Tool specifications							
Ø160 mm, Z 4, Length 32 mm							
Material HSS							
Operations	Probe	Flute 1	O.D.1	Plung. Rough	Pregrinding	fin. left	fin. Right
Feed [mm/Min]	2000	80	120	40	80	100	100
Power [kW]		3	3	4	3	2	2
Cutting feed [m/s]		32	32	32	32	32	32
Used wheels		15	11	31	31	30	32
Grinding time [s]	21	338	291	571	366	325	325
Total cycle time	37 Min 17						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

Roughing with 14A1

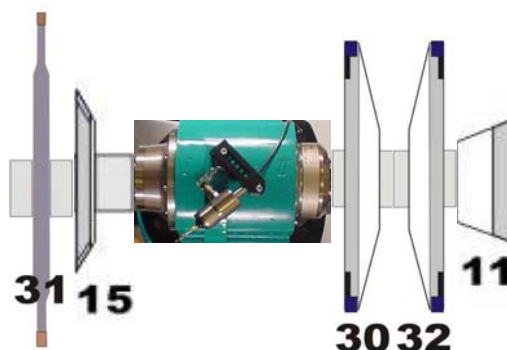


Finishing with 12C9



### 2. Used Grinding Wheels

15 Ø125 1V1 B126  
 11 Ø100 11V9 B126  
 31 Ø250 14A1 B126  
 30 Ø250 12C9 B126  
 32 Ø250 14A1 B126



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR  
 Control: Fanuc 160i  
 Coolant: Synthetic Oil, pressure 6 - 7 bar  
 Software: Quinto 4.3, DXQ

responsible engineer: OP, 20.11.07

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